

SHIP JUNE (11)

Work Order ID 133360

133360

Page 1

Monday, June 08, 2015 8:54:13 AM

Item ID: D4049-141

Accept

N9000040100

Revision ID: PRELIM

Item Name: Mounting Lug Assembly, LH

Stop *NS2*

Start Date: 6/08/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/10/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date: 5-6-8

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4049

ET Rev C

100

Weld per dwg A/R S.S. rod Batch: M123823 0.00

100

Large Fab

Memo

0.00

Large Fab

1- Weld lug on bracket as per dwg D4049 using DT jig
 2- Tack weld a piece of s.s. rod on back of D4049-13 where lug is located, to hang the part when powdercoating.

2 B 15-6-10

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

2 JUN 10 2015

DAS
24
9-89

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

2 JUN 10 2015

DAS
24
9-89

10/11/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																												
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval																																																										
Description Work Order Deviation		Disposition		Completed By																																																										
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Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td style="width:50%;">Environment ☐</td><td style="width:50%;">No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr><td style="width:33%;">Pressure/Forced ☐</td><td style="width:33%;">Temperature/Cure ☐</td><td style="width:33%;">Power Loss/Surge ☐</td></tr> <tr><td>Bending ☐</td><td>Set-up ☐</td><td>Folio/Program ☐</td></tr> <tr><td>Centre Not Concentric ☐</td><td>BOM/Route ☐</td><td>Grain ☐</td></tr> <tr><td>Cracks ☐</td><td>Broken/Damage/Defect ☐</td><td>Weld ☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave ☐</td><td>Inspection Incomplete/Unqualified ☐</td><td>Wrong Stock Pulled ☐</td></tr> <tr><td>Cuffs ☐</td><td>Contamination ☐</td><td>Out of Sequence ☐</td></tr> <tr><td>Crushing ☐</td><td>Countersink ☐</td><td>Off-set ☐</td></tr> <tr><td>Heat Treat ☐</td><td>Cut Too Short ☐</td><td>Mislabeled ☐</td></tr> <tr><td>Wave/Twist in Tube ☐</td><td>Instructions Incomplete/Unclear ☐</td><td>Fit/Function ☐</td></tr> <tr><td>Marks/Chatter ☐</td><td>Drill Holes ☐</td><td>Misaligned/off center ☐</td></tr> <tr><td colspan="3" style="text-align: center;">OTHER : ☐</td></tr> </table>				Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Crushing ☐	Countersink ☐	Off-set ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	OTHER : ☐		
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Work Order ID 133360

Monday, June 08, 2015 8:54:13 AM

133360

Page 2

Item ID: D4049-141 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Mounting Lug Assembly, LH
Start Date: 6/08/15 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/10/15 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130	<i>M 131 545</i>					<i>2</i>	<i>0</i>	<i>15-6-10</i>	
Powdercoat	Memo	0.00							
Powder Coating	1- POWDER COAT: Start Time: <i>11:20:4000</i> Oven Temperature: Finish Time: <i>12:20</i>								
	2- When powdercoated, ONLY grind off welding rod flush								
	3- touch up with paint								
140	QC3- Inspect Part Finish	0.00							
140						<i>(2)</i>			
QC	Memo	0.00							
Quality Control									

DAS 34 9-89

DAS 38 9-89

JUN 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Work Order ID 133360

Monday, June 08, 2015 8:54:13 AM

133360

Page 3

Item ID: D4049-141

Accept

N900040100

Setup Start *NS1*

Revision ID: PRELIM

Stop *NS2*

Item Name: Mounting Lug Assembly, LH

Start Date: 6/08/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/10/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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145 QC5- Inspect part completeness to step on W/O

0.00

145

QC

Memo

0.00

Quality Control

JUN 11 2015

150 Identify as per dwg & Stock Location *PRELIM*

0.00

150

Packaging

Memo

0.00

Packaging

*1 scrap use
for trial fit
+D
1605-27*

160 QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MAY 27 2016

POSITIVE RECALL

EFFECTIVE

VIDAS

AUTH

1568

RELEASED

8

DATE

16-05-27

MS 6-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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OTHER : ☐					

Monday, June 08, 2015 8:54:19 AM

133360

D4049-141

Required Date: 6/10/15

Required Qty: 2.00

Comments: IPP REV:A 15.06.08 NEW ISSUE DD VERF:JLM

[illegible]

DQA: _____ Date: _____



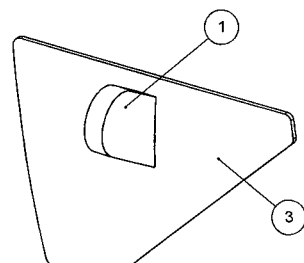
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

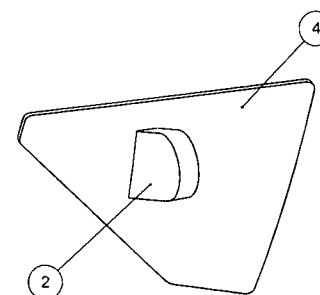
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D4049-041	MOUNTING LUG ASSY, LH
		X	D4049-042	MOUNTING LUG ASSY, RH
1	1		D4049-1	LUG
2		1	D4049-2	LUG
3	1		D4049-3	MOUNTING PLATE, LH
4		1	D4049-4	MOUNTING PLATE, RH



D4049-041 MOUNTING LUG ASSY, LH



D4049-042 MOUNTING LUG ASSY, RH

Handwritten signature and date:
 15.6.8
 133360

PRELIMINARY ISSUE

C	ADD -141/-142; ZN B4-3, B8-3, B4-6, B3-5, ADD -11/-12; ZN A4-10, B2-11, ADD -13/-14; ZN C1-12, A1-12, REVISE DIM; ZN B5-3, B4-4, ADD -2 VIEW; ZN B2-7	VS	15.05.26
B	80° WAS 83°, 0.33 WAS 0.55 & 2.10 WAS 2.50 (ZN C6-2)	RF	10.03.19
A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 1 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

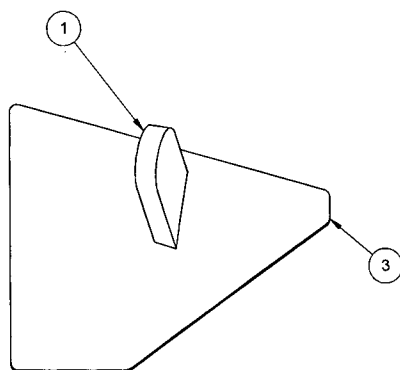
8 7 6 5 4 3 2 1

D

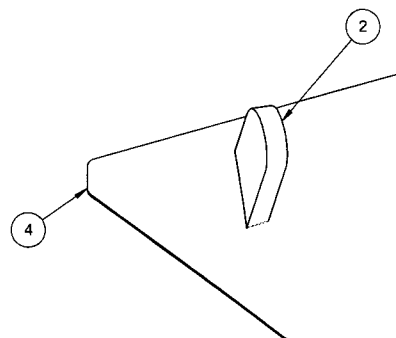
C

B

A



 **D4049-141 MOUNTING LUG ASSY, LH**



 **D4049-142 MOUNTING LUG ASSY, RH**

ITEM	QTY -141	QTY -142	P/N	DESCRIPTION
	X		D4049-141	MOUNTING LUG ASSY, LH
		X	D4049-142	MOUNTING LUG ASSY, RH
1	1		D4049-11	LUG
2		1	D4049-12	LUG
3	1		D4049-13	MOUNTING PLATE, LH
4		1	D4049-14	MOUNTING PLATE, RH

D

C

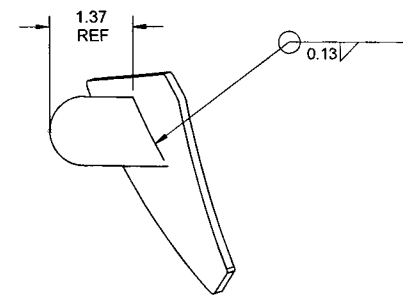
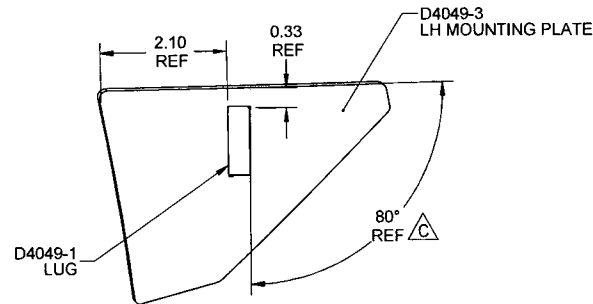
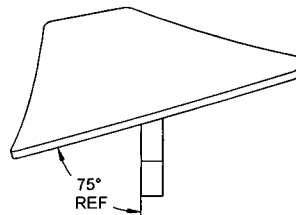
B

A

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. D4049	REV. C1
MFG. APPR.	DD		SHEET 2 OF 12
APPROVED		TITLE MOUNTING LUG ASSY	SCALE
DE APPR.			NTS
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



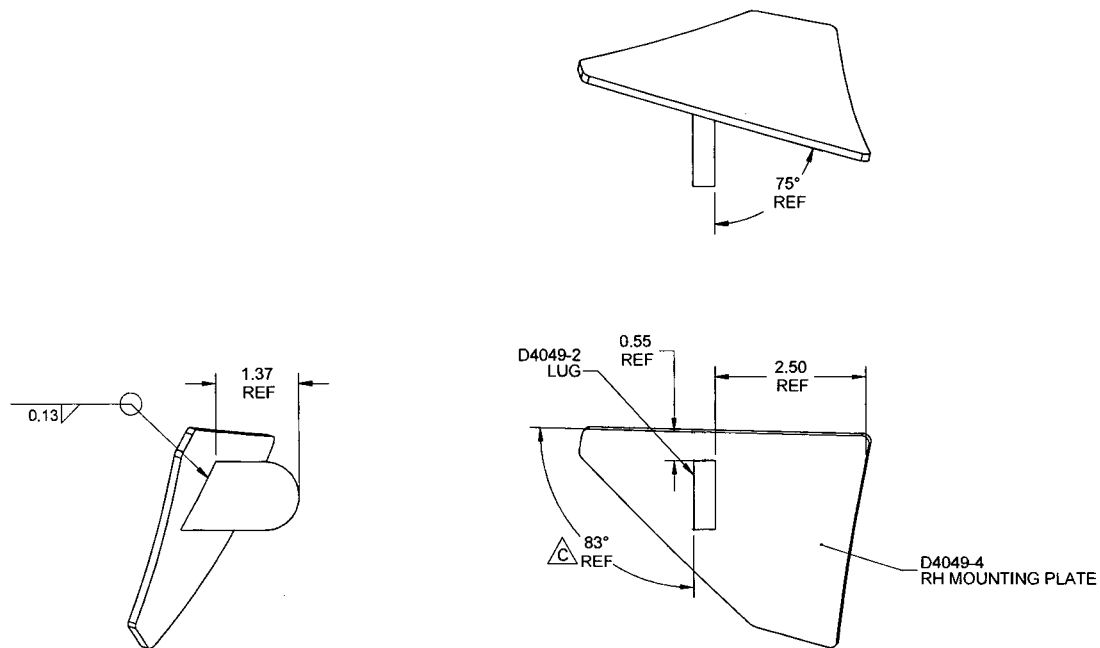
8 D4049-041 MOUNTING LUG ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DT9584

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 3 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4049-042 MOUNTING LUG ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DT9583

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO. D4049	REV. C1
MFG. APPR.	DD		SHEET 4 OF 12
APPROVED		TITLE MOUNTING LUG ASSY	SCALE NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	15.05.26		

8 7 6 5 4 3 2 1

D

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C

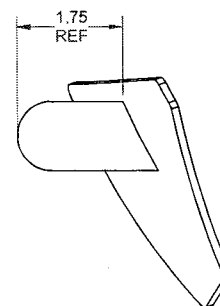
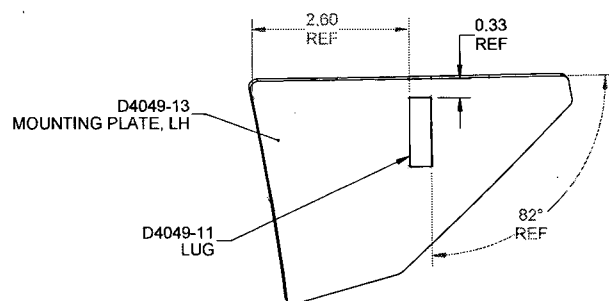
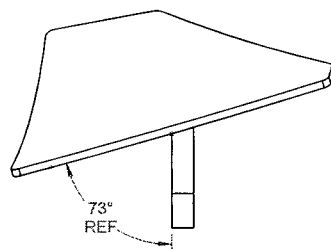
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8 D4049-141 MOUNTING LUG ASSY, LH C

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-141" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.77 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DTXXXX

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 5 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

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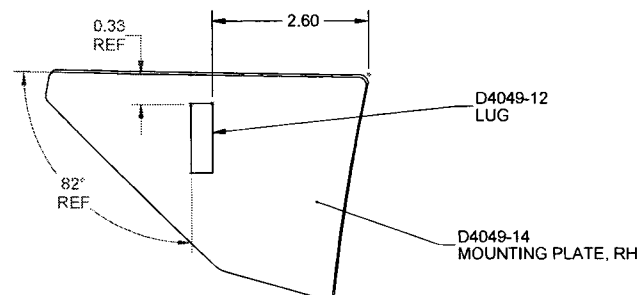
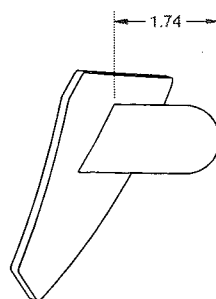
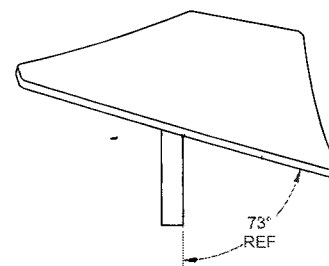
C

B

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A

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8 D4049-142 MOUNTING LUG ASSY, RH C

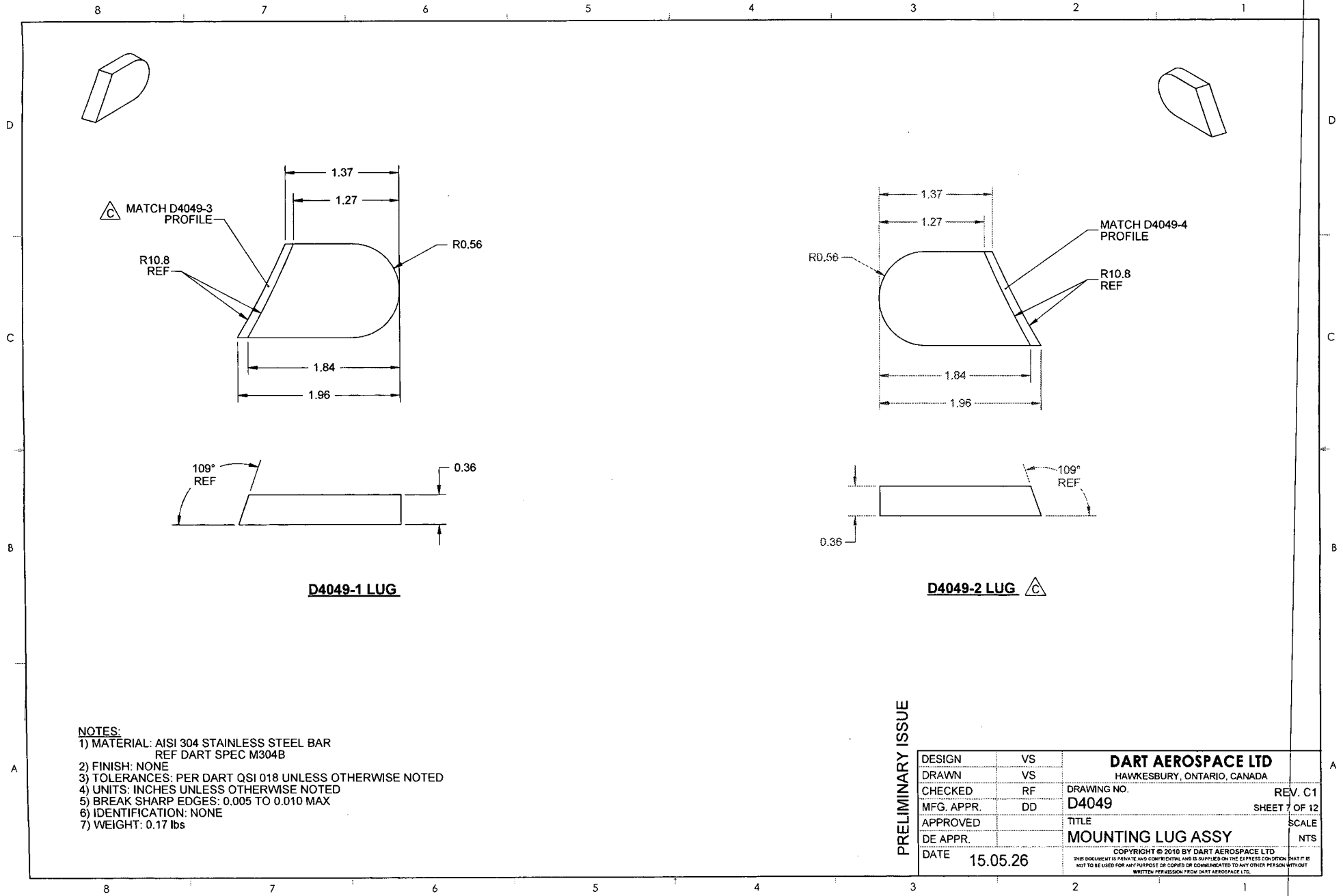
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-142" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.77 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DTXXXX

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 8 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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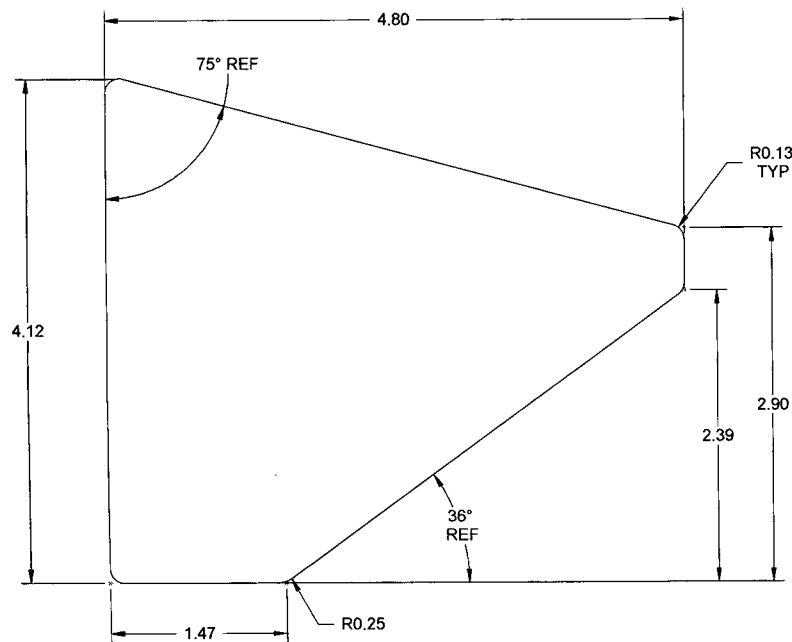


NOTES:

- 1) MATERIAL: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs

PRELIMINARY ISSUE

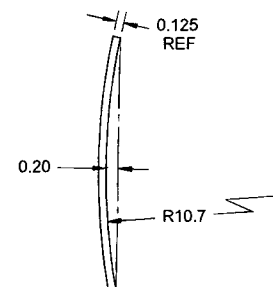
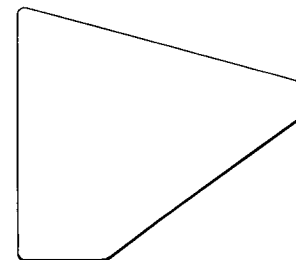
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DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 7 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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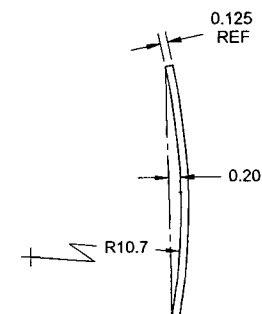
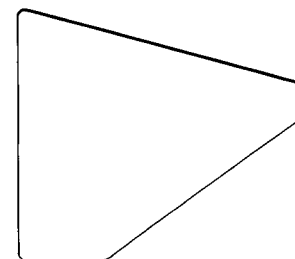
D4049-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH, 0.125" THICK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.46 lbs



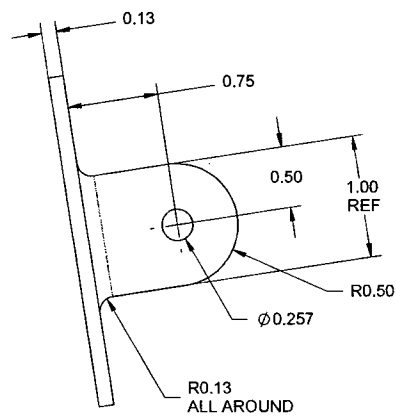
D4049-3 MOUNTING PLATE, LH
(MAKE FROM D4049-3F FLAT PATTERN)



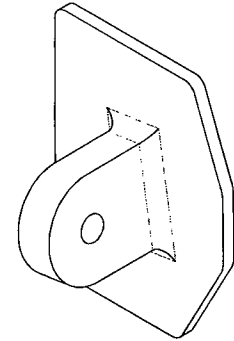
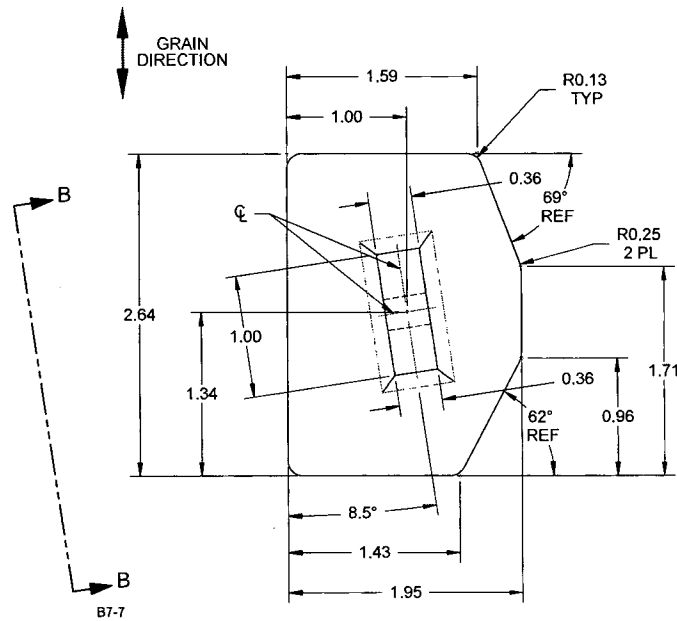
D4049-4 MOUNTING PLATE, RH
(MAKE FROM D4049-3F FLAT PATTERN)

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 8 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
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VIEW B-B 85-7



D4049-8 MOUNTING LUG, RH

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221
PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-8" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 10 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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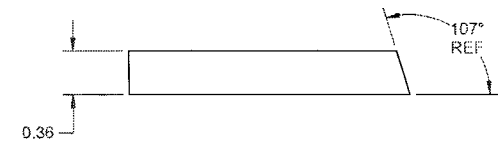
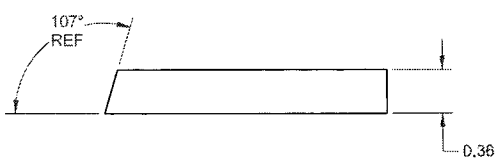
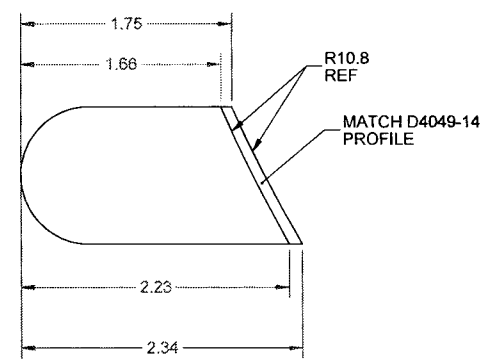
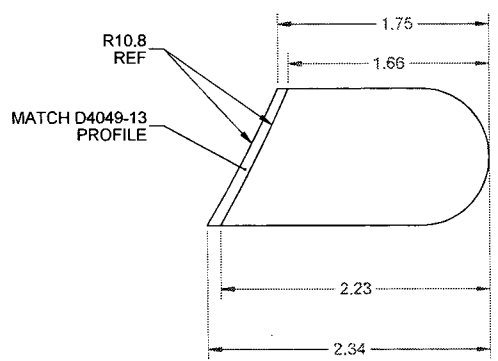
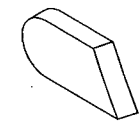
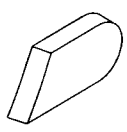
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D4049-11 LUG

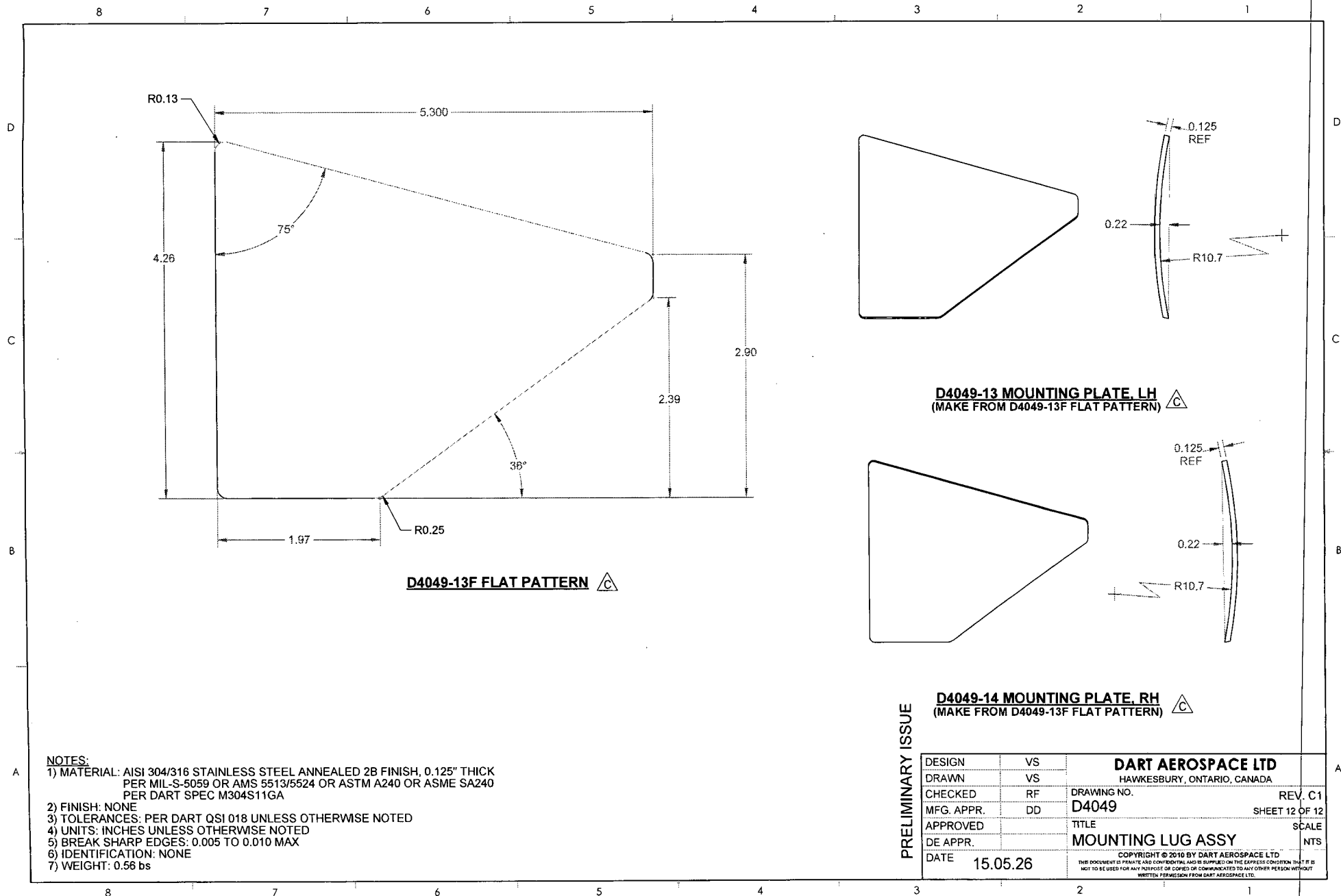
D4049-12 LUG

- NOTES:**
- 1) MATERIAL: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.22 lbs

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 11 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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PRELIMINARY ISSUE

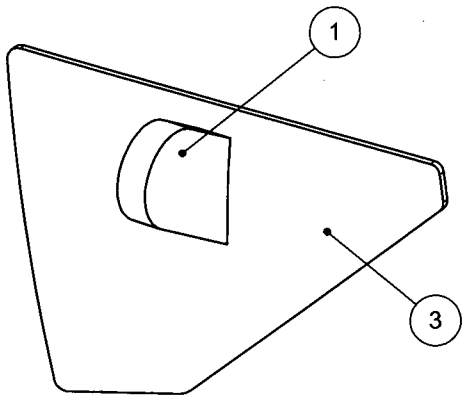
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 12 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
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JTG DT 9584 INSPECTION SHEET

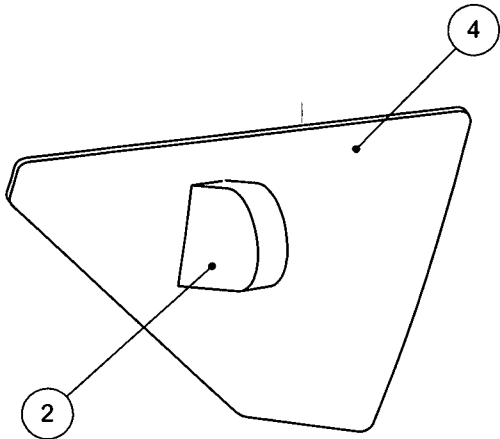
Measured by:	<i>Q</i>	Checked by:		QC Inspector:	
Date:	<i>15-6-10</i>	Date:		Date:	

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D4049-041	MOUNTING LUG ASSY, LH
		X	D4049-042	MOUNTING LUG ASSY, RH
1	1		D4049-1	LUG
2		1	D4049-2	LUG
3	1		D4049-3	MOUNTING PLATE, LH
4		1	D4049-4	MOUNTING PLATE, RH



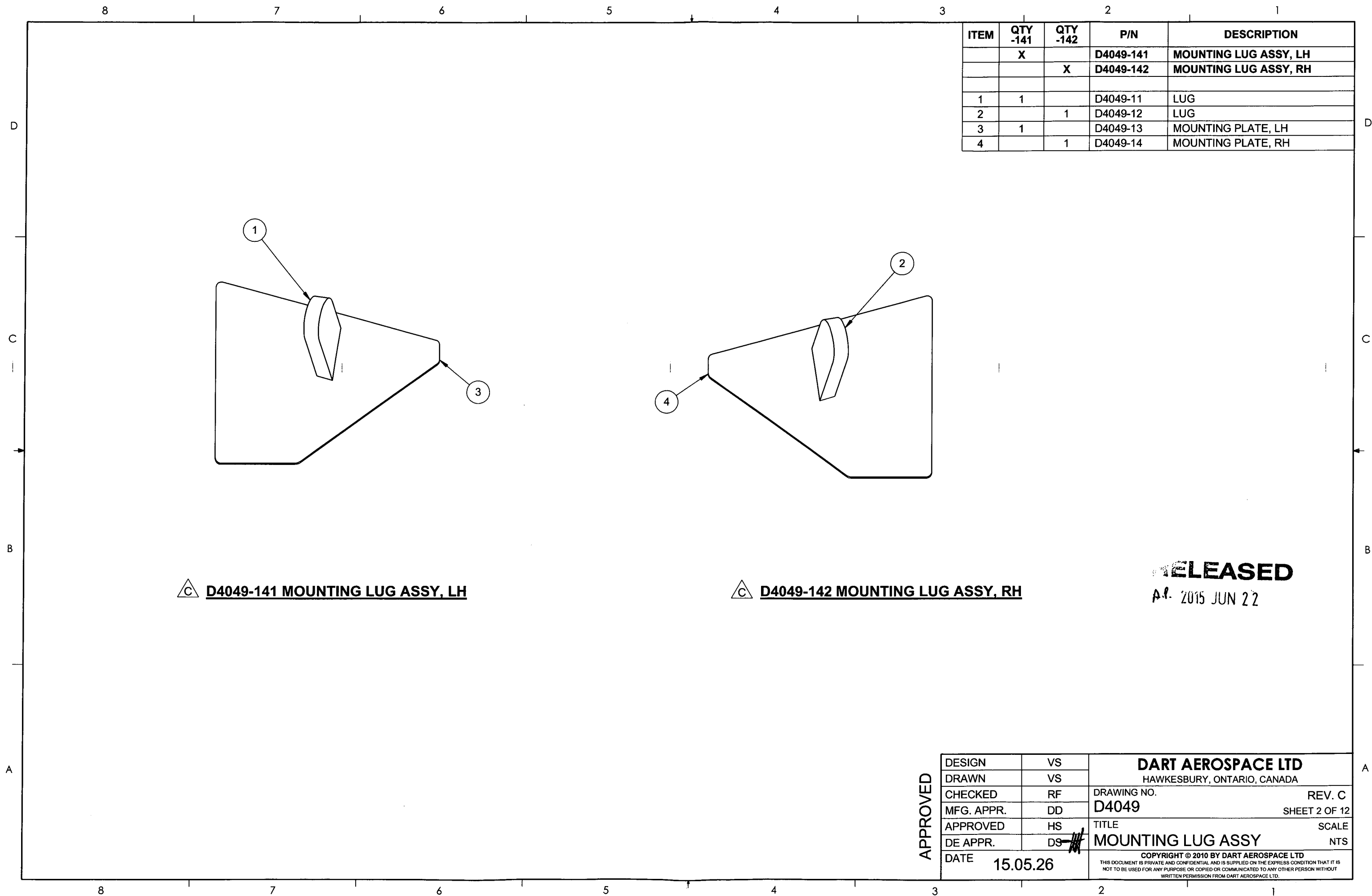
D4049-041 MOUNTING LUG ASSY, LH



D4049-042 MOUNTING LUG ASSY, RH

RELEASED
A-P 2015 JUN 22
EEN 15-585

C	PER NCR 15-4825, ADD -141/-142; ZN B4-3, B8-3, B4-6, B3-5, ADD -11/-12; ZN A4-10, B2-11, ADD -13/-14; ZN C1-12, A1-12, REVISE DIM; ZN B5-3, B4-4, ADD -2 VIEW; ZN B2-7	VS	15.05.26
B	80° WAS 83°, 0.33 WAS 0.55 & 2.10 WAS 2.50 (ZN C6-2)	RF	10.03.19
A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4049	SHEET 1 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	MOUNTING LUG ASSY	NTS
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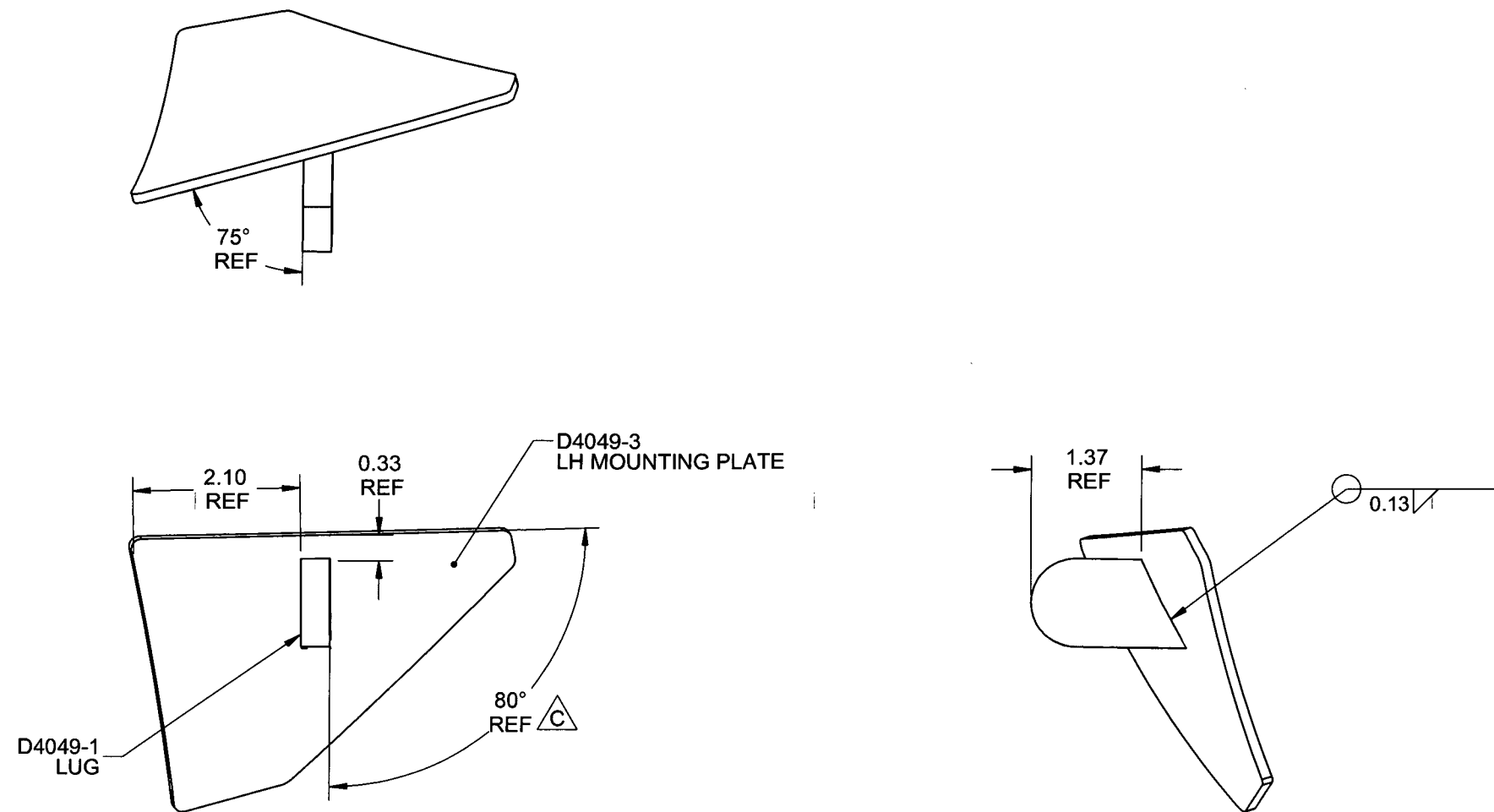
ITEM	QTY -141	QTY -142	P/N	DESCRIPTION
	X		D4049-141	MOUNTING LUG ASSY, LH
		X	D4049-142	MOUNTING LUG ASSY, RH
1	1		D4049-11	LUG
2		1	D4049-12	LUG
3	1		D4049-13	MOUNTING PLATE, LH
4		1	D4049-14	MOUNTING PLATE, RH

△ C D4049-141 MOUNTING LUG ASSY, LH

△ C D4049-142 MOUNTING LUG ASSY, RH

RELEASED
A.I. 2015 JUN 22

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	RF	DRAWING NO. D4049	REV. C
	MFG. APPR.	DD	SHEET 2 OF 12	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	MOUNTING LUG ASSY	NTS
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8 D4049-041 MOUNTING LUG ASSY, LH

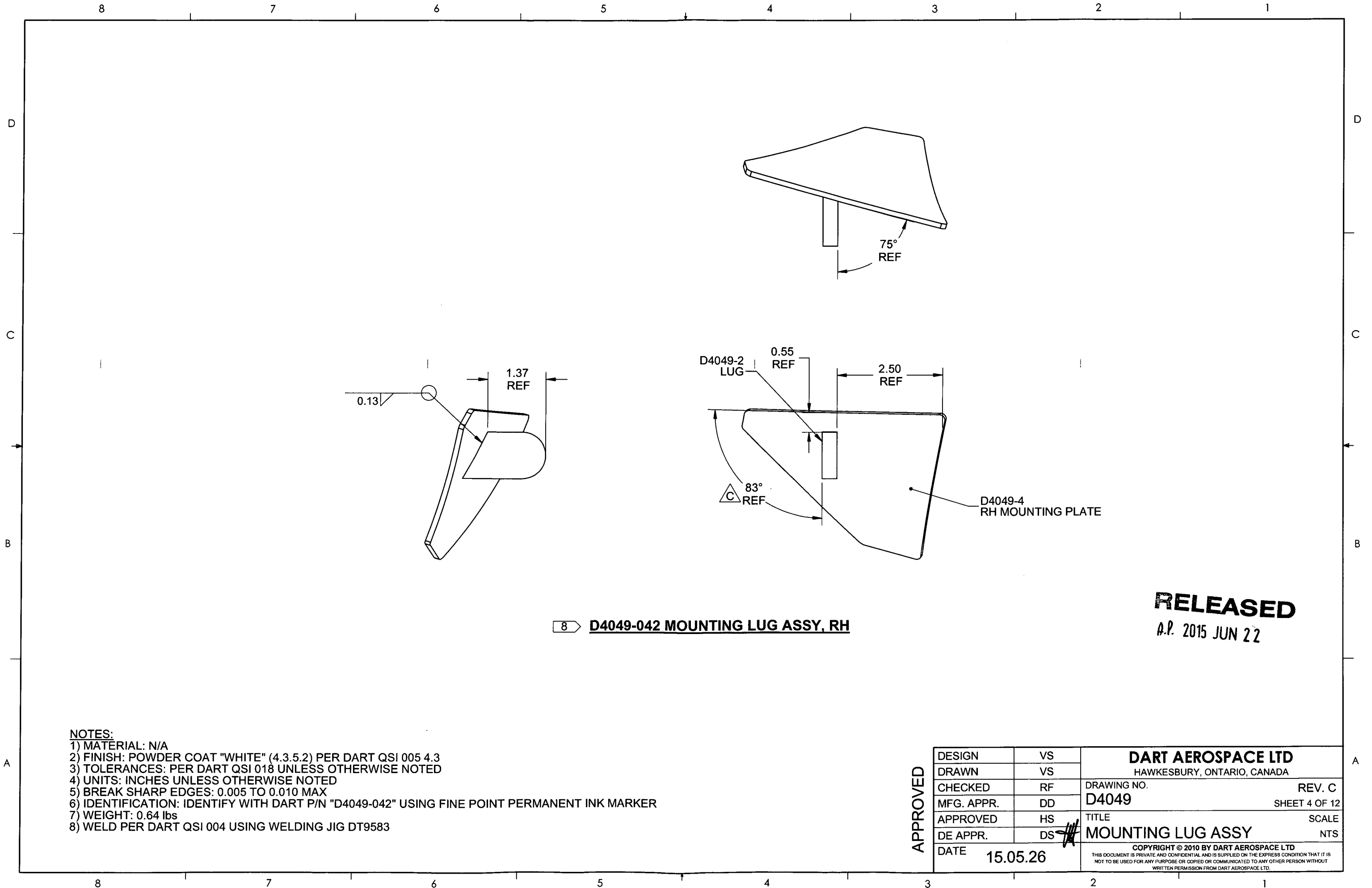
RELEASED
A.P. 2015 JUN 22

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DT9584

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4049	SHEET 3 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	MOUNTING LUG ASSY	NTS
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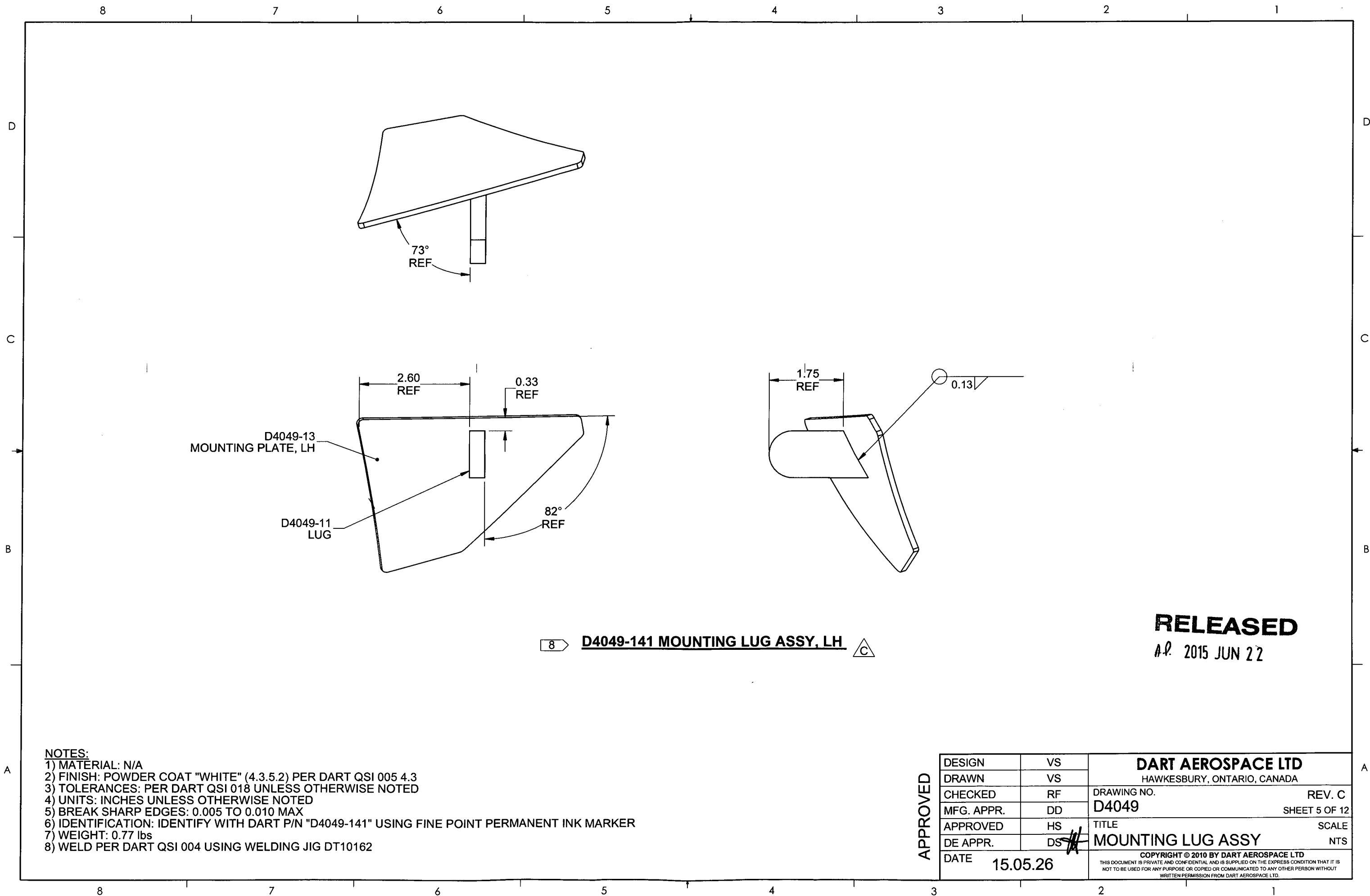
8 D4049-042 MOUNTING LUG ASSY, RH

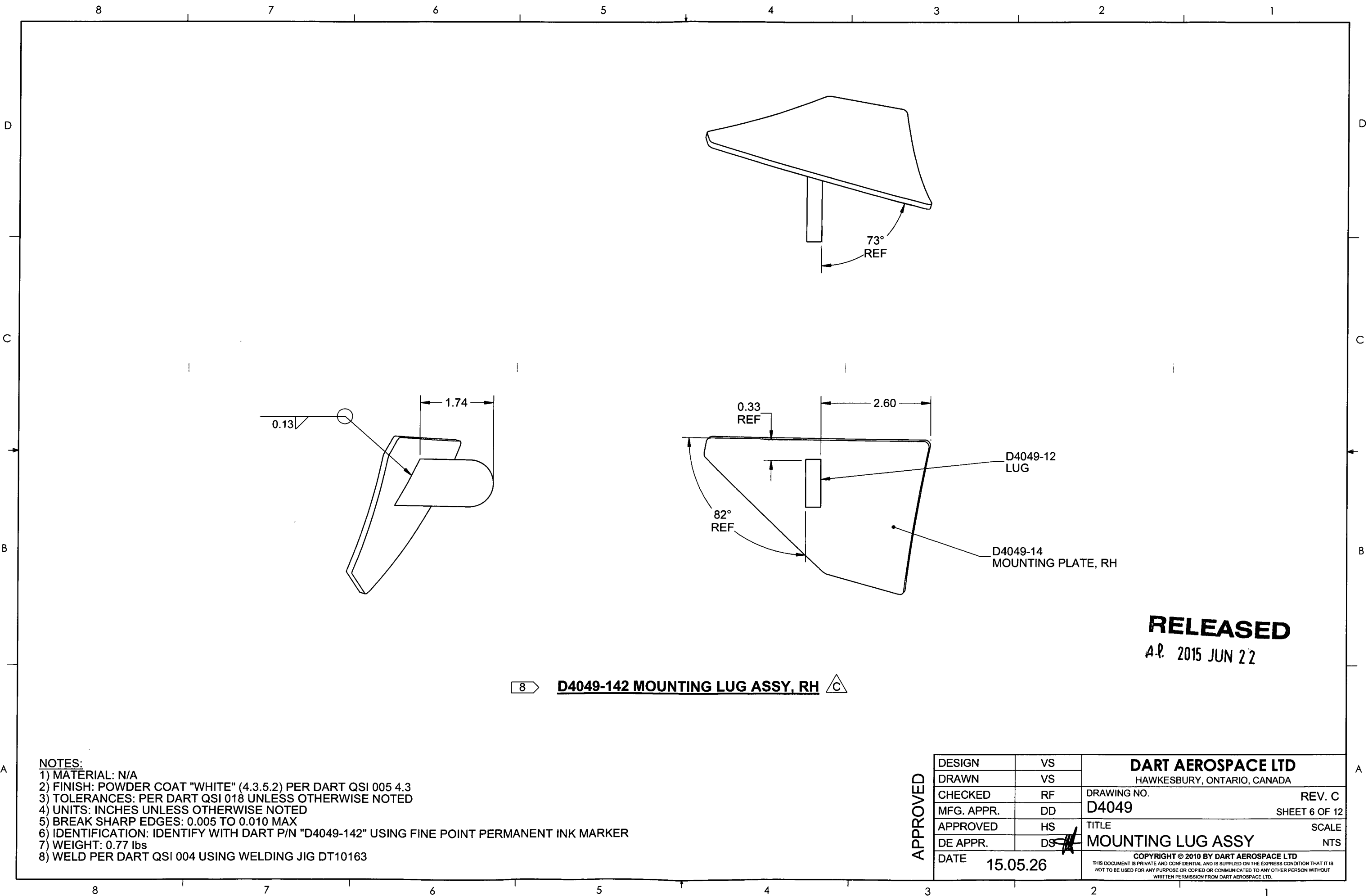
RELEASED
A.P. 2015 JUN 22

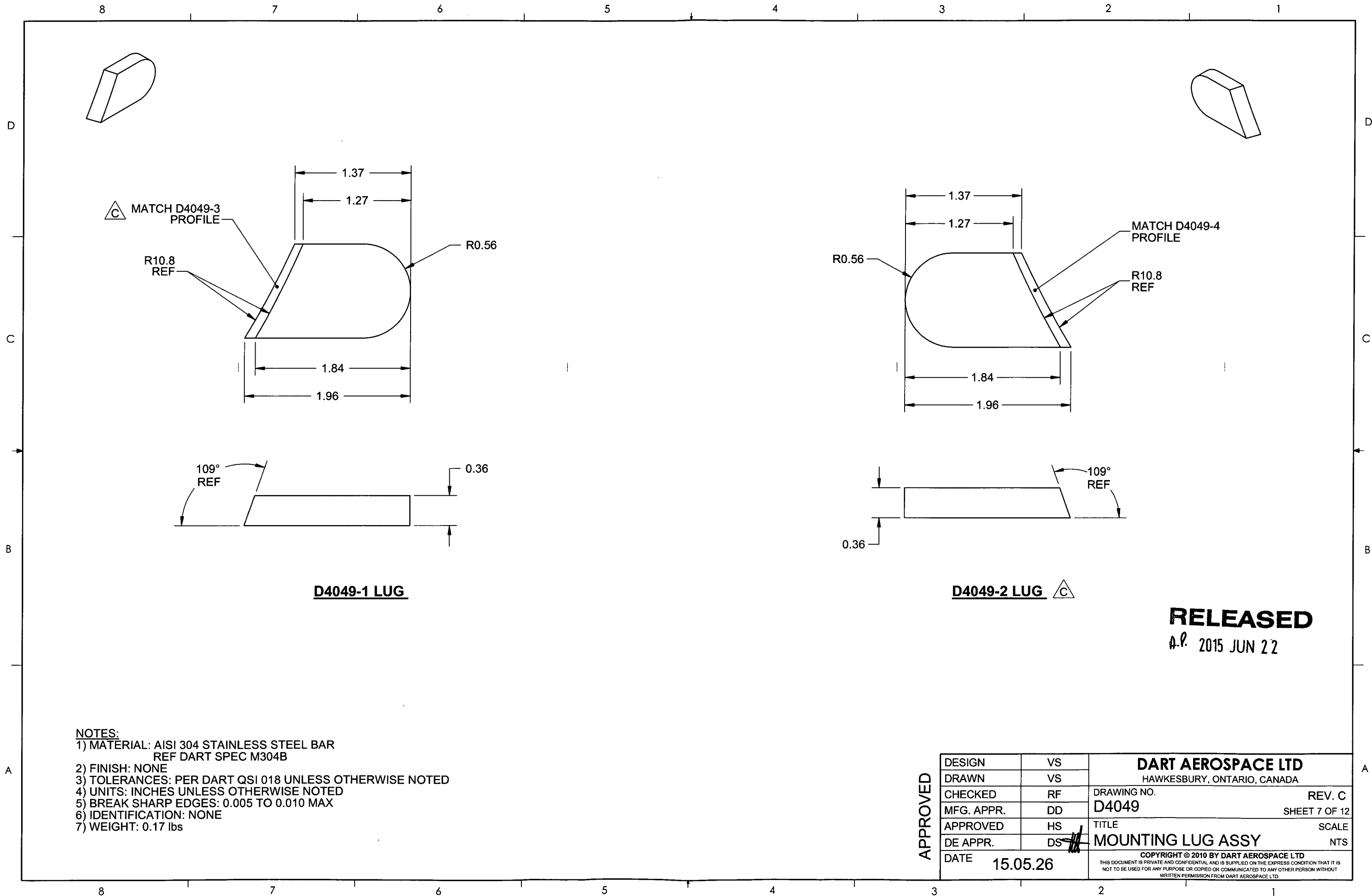
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-042" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.64 lbs
 - 8) WELD PER DART QSI 004 USING WELDING JIG DT9583

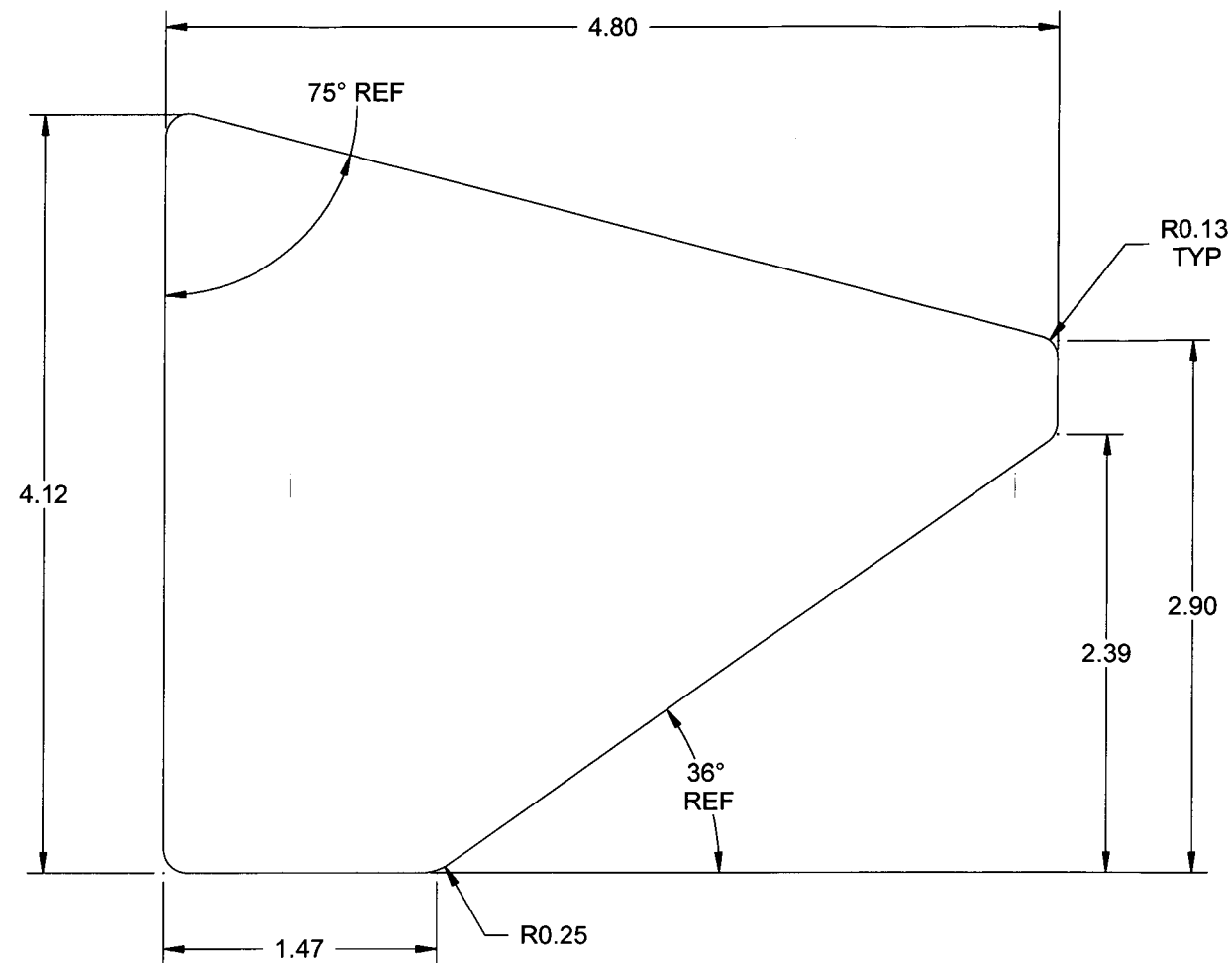
APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4049	SHEET 4 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	MOUNTING LUG ASSY	NTS
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

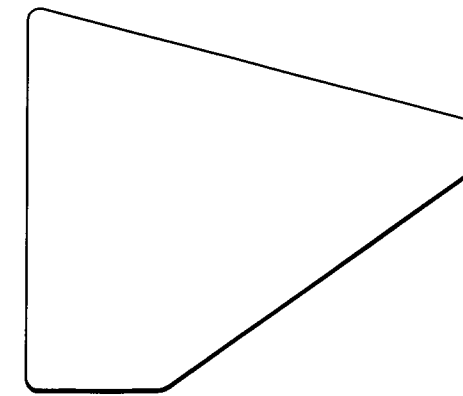




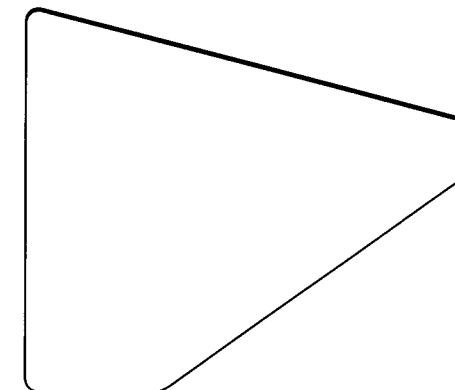
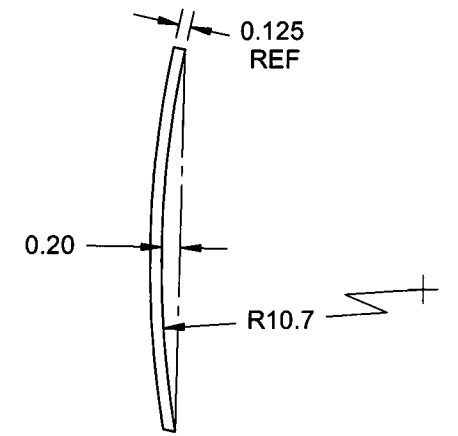




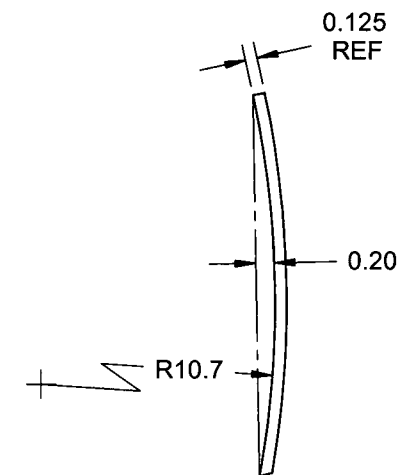
D4049-3F FLAT PATTERN



**D4049-3 MOUNTING PLATE, LH
(MAKE FROM D4049-3F FLAT PATTERN)**



**D4049-4 MOUNTING PLATE, RH
(MAKE FROM D4049-3F FLAT PATTERN)**



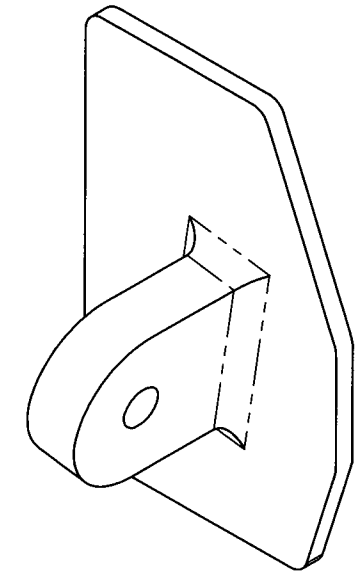
RELEASED
2015 JUN 22 A9

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH, 0.125" THICK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.46 lbs

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4049	SHEET 8 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	MOUNTING LUG ASSY	NTS
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A.P. 2015 JUN 22

7) WEIGHT: 0.10 lbs

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	RF	DRAWING NO.	REV. C
	MFG. APPR.	DD	D4049	SHEET 9 OF 12
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	MOUNTING LUG ASSY	NTS
	DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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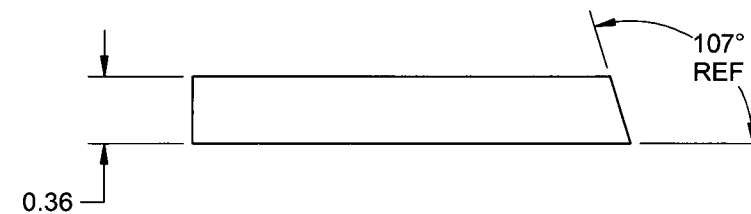
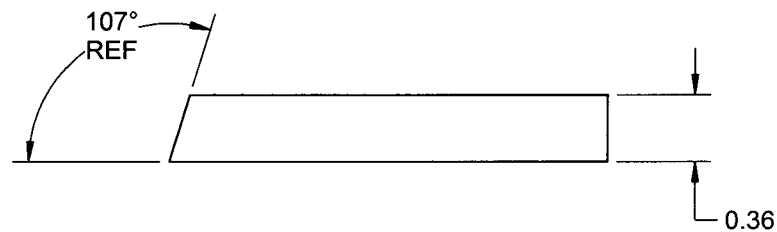
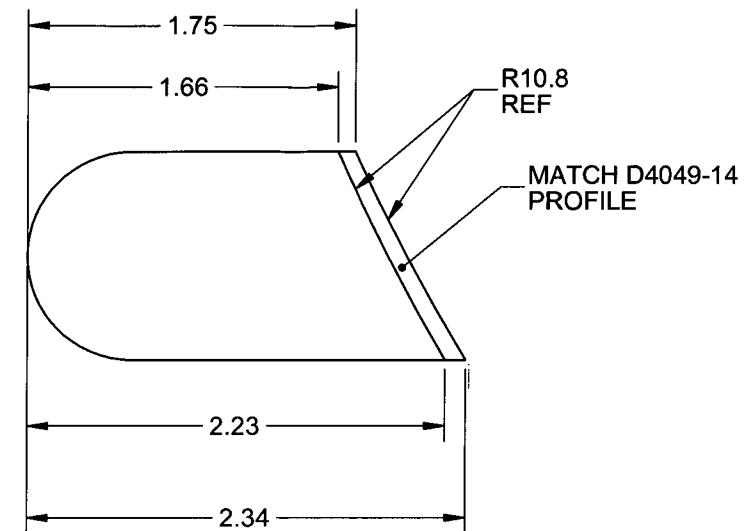
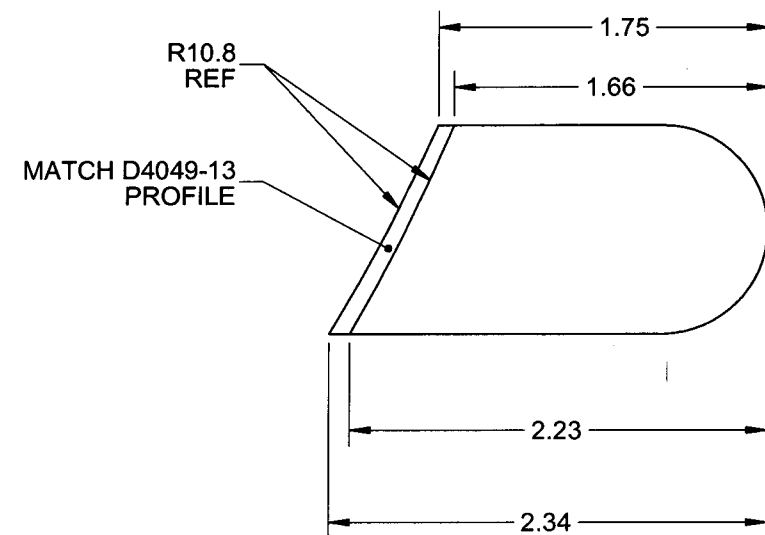
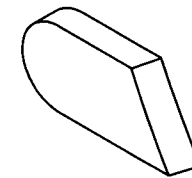
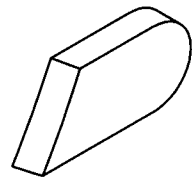
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D4049-11 LUG 

D4049-12 LUG 

RELEASED

APR 2015 JUN 22

NOTES:

- 1) MATERIAL: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO. D4049	REV. C
MFG. APPR.	DD	SHEET 11 OF 12	
APPROVED	HS	TITLE	SCALE
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